

Date: Wednesday, 2/15/2006 3:50:24 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 25863	
Estimate Number : 10008	
P.O. Number : N/A	Part Number : D2591
This Issue : 2/15/2006 S.O. No. : N/A	Drawing Number : D2591 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : D
Previous Run : 24898	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 3/15/2006
Checked & Approved By : J. 06.02.16	Qty: 30 Um: Each
Comment : Est Rev: Removed from 9 Digit 05-10-25 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.2340 f(s)/Unit Total: 7.0200 f(s)  
ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)  
Batch: M19429 SA 06.02.21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
Cut blanks: 2.700" long SA 06.02.21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
1- Machine as per Folio FA 039 and Dwg D2591  
2-Deburr if required J.L/SA 06.02.22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.L/SA 06.02.22

5.0	QC8	SECOND CHECK
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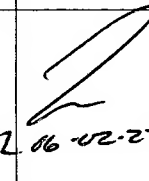


Comment: SECOND CHECK J.L 06/02/23 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/02/27.

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.02.22	3	- <del>shim</del> moved while machining	CP 06.02.22 per QS1042	- shim jaws - jaws should be remade - Scrup & destroyed REPLACED	SD 06.02.22	 06-02-22	CP 06.02.22 per QS1042	 06-02-22

NOTE: Date & initial all entries

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Drawing Name: LUG

Job Number: 25863

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS10

C206102/24 (30)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06102/27

Job Completion



h 06-02-27 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	25863
<b>Description:</b> GHW Lug		<b>Part Number:</b>	D2591
<b>Inspection Dwg:</b> D2591	<b>Rev:</b> D		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## Prototype

[illegible]

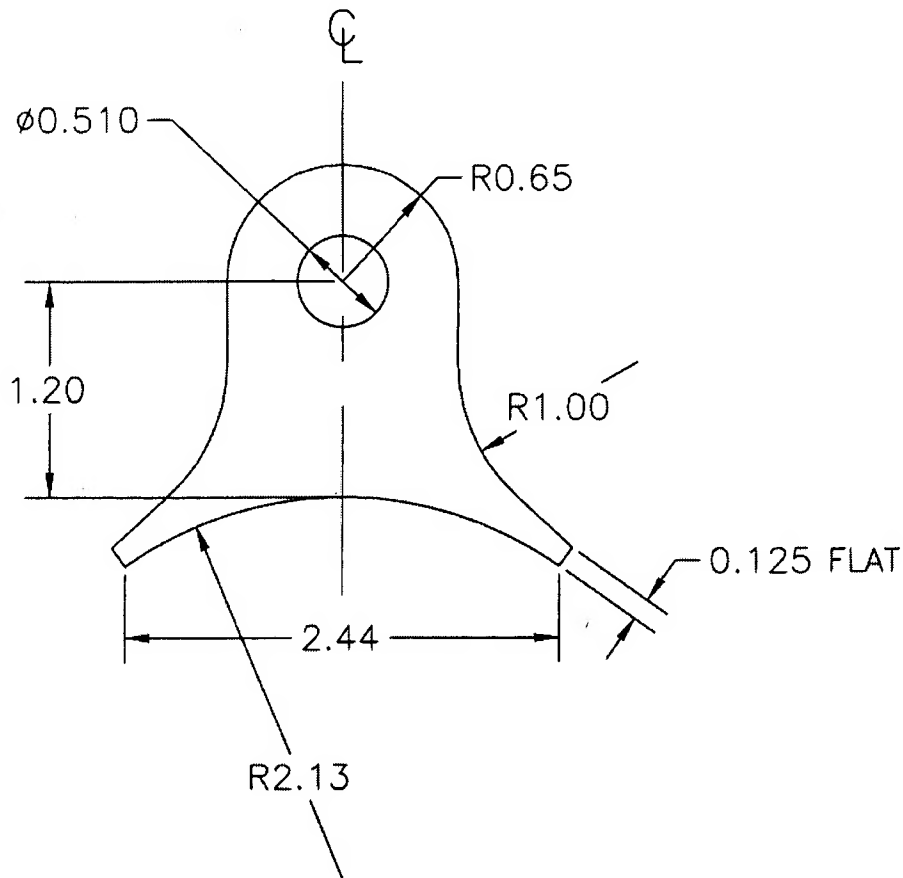
Measured by:	SD	Audited by:	PG	Prototype Approval:	N/A
Date:	06.02.22	Date:	06.02.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DSI 9161-011	KJ/JLM	



DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED  
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~  
MATERIAL: ASTM A36 STEEL 0.50 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE  
ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 25863